Work Orde Tuesday, July 19									-	, , 44	Page
Item ID:	D3278-041			Accept				s s	etup Star	rt	
Revision ID: Item Name:	Support Asser	mbly							Sto	р	
Start Date: Required Date: Reference:	7/19/2011 7/25/2011	Start Qty: 40.00 Req'd Qty: 40.00			Cust Item l Customer:	ID:					
Approvals:	Process Pla	ın: //	Date: //- 07-	19 Tooling:	D	ate:		R	kun Star		
•	QC:	(Date:	,	D	ate:	,		Stop	p	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3278	Rev	C		.*							
100		Small Fab		0.00				FB	1/2/	23/	
Small Fab		Memo	*	0.00	5			The state of the s			
Small Fab		Rivet spacer	s with support as per Dw	/g D3278.					,		
		QC5- Inspect part comple	eteness to step on W/O	0.00	, 1			(44)			
QC		Memo		0.00 KW W	(07/23						

120

Small Fab

Small Fab

Quality Control

Small Fab

Memo Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041

0.00

0.00

Julog /23 (4)

Dart Aerospace	Ltd
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W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
										10-01-01-01-01-01-01-01-01-01-01-01-01-0				
Part No	:	PAR #:	Fault Categ	Jory:	NCR:	Yes N	lo DQ	A:	Date:					
	R	esolution:	Disposition):	_ QA: I	VC Clo	sed:		Date:					
NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)											
DATE	CTED	Description of NC			ion B		Verific	ation	Approval	Approval				
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector				
							-							
					1		1							

Work Order ID 72132 Tuesday, July 19, 2011 12:43:10 PM



Page 2

Item ID:

D3278-041

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Support Assembly

7/19/2011

Start Qty: 40.00

Required Date: 7/25/2011

QC:

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

130

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ **Run Hours**

0.00 8 11/08/23

Tool ID

Tool # Plan

Code Qty

Accept

Reject Qty

Reject Insp. Number Stamp

140

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

	•									-
W/O:	:		V	VORK ORDER CH	IANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								
Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	QA	: N/C Ck	osed:		Date: _	
NCR:		V	VORK ORI	DER NON-CONFO	DRMANCE	(NCR	(1)	-		
DATE	STEP	Description of NC		Corrective Action	Section B	Ciam 0	Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Descri		Sign & Date	Section	on C	Chief Eng	QC Inspector
				-	···					

Picklist Print

Tuesday, July 19, 2011 12:43:17 PM

Work Order ID: 72132

Parent Item: D3278-041

Parent Item Name:

Support Assembly





Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 40.00 Required Qty: 40.00

Comments:

IPP: □A□04.04.19□New issue□KJ/JLM□

B 07.08.21 Chg rivet per PAR185

EC Verified by: JLM

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
03278-1		Manufactured	No			100	Each	5.0000	1 	40	1/02/	£3	
		e		Location	<u>n</u>	Loc	<u>Oty</u>	Loc Code					
				GA			5			4	BL	78891	2
					68956		5		_	5	- <i>-</i>	100/	35x/
3278-2		Manufactured	No		*	100	Each	0.0000	1	40	<i>,</i>		
upport			_ &			B6:	7888 (UOX)		5	40%	123	·
3278-3 		Manufactured	No			100	Each	100.0000	1 /	40	/ [[/v]	/ P/23	>
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				Locatio	n	Loc	Otv	Loc Code			•		
				GA	_		100						
					68340		34			34	_		
					70984		66			6	_		
1S21042L4		Purchased	No			100	Each	3,764.000		80			
 										{	D11-0	D9-2=	3
				Locatio	, <u>n</u>	Loc	<u>Oty</u>	Loc Code					
				ST300			3764				_		
					117441		1517		1		F.Ai		
					117601	•	747		//-	4			
					117885		1500		40	TOO	XXX		

Duit Aci	ospao.	CEIG								-		
W/O:			WO	RK ORDER CHANG	GES							
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
. &												
Part No		PAR #:	Fault Category: NCF			CR: Yes No DQA: Date:						
	R	desolution:	Disposition		QA: N/	C Clos	ed:		Date: _			
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (N	ICR)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng		gn & late	Verific Section		Approval Chief Eng	Approval QC Inspector		
			Olilot Ellig	Sillor Ellig		uic						
										·		

Picklist Print

Tuesday, July 19, 2011 12:43:17 PM

Page 2

Work Order ID: 72132

Parent Item:

D3278-041

Parent Item Name: Support Assembly

NAS1149D0463J Purchased



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A

AN960JD416

MS20426AD3-6



Purchased

Manufactured

Purchased

No

No

No

No

120

Each

1,226.000

80

<u>Location</u>	Loc	e Oty	Loc Code
ST357		1226	
117962		32	
118078		594	
118350		300	
118351		300	
	120	Each	0.0000

m118384

(00x

160

120

159.0000 Each

2

80

Lug

Rivet

Washer

D2230-1

Location	Loc	<u>Oty</u>	Loc Code
ST476		159	
67826		6	
69179		53	
69821		100	
	120	Each	3,525.000

<u>oc</u>	Code	

Location	Loc Oty	Loc Co
ST316	3525	
10505	115	
116289	3410	

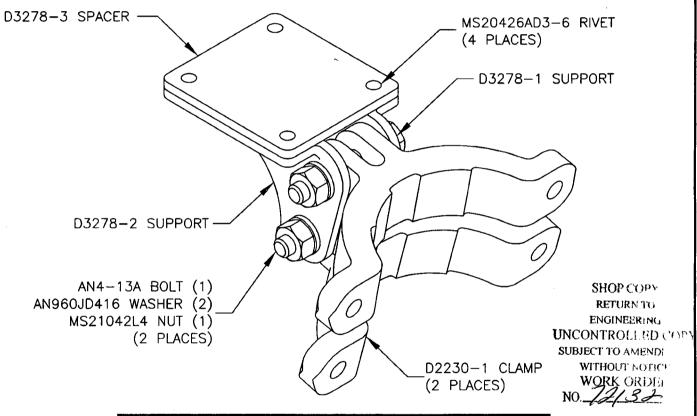
DuitAu	oopaoc								, 🛥
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:		_ Date: _	
	Re	solution:	Dispositio	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
	T	Description of NC		Corrective Action Section	on B	Vorifica	tion	Approval	Approval
DATE	STEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Verification Section C		Approval QC Inspector
		•							
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	4) #	D3278 SHEET 1 0	OF 3
DA	TE		TITLE SO	CALE
0	7.07.24	}	SUPPORT ASSEMBLY	NTS
A	\	04.03.03	NEW ISSUE	
E	3	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
)	07.07.24	CHANGED RIVETS PER PAR #185	



D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
Х	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

M11-07-9

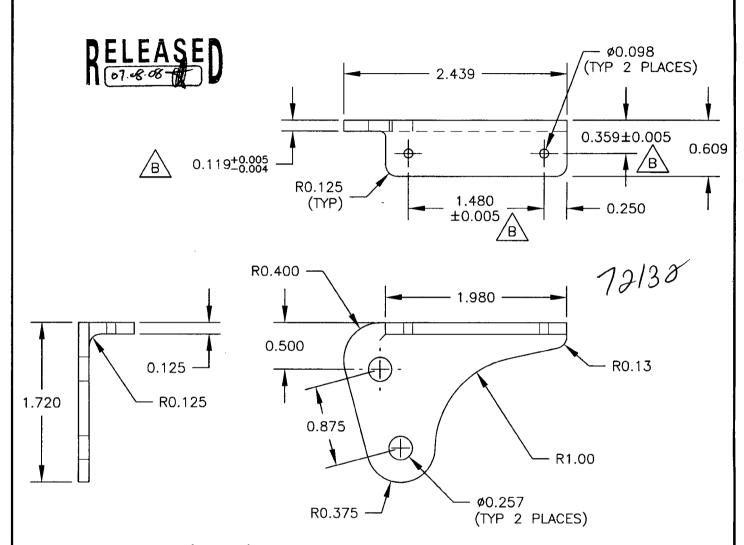
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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Cate	egory:	NCR: Yes	No DQ	A :	Date:	
Resolution:			Disposition:		QA: N/C C	\: N/C Closed:		Date:	
NCR:		W	ORK ORD	ER NON-CONFORMAI	NCE (NCI	₹)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
	Section A		Initial Chief Eng			Sign & Section C		Chief Eng	QC Inspector
						,			
							 		



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CHECKED	APPROVED	DRAWING NO.		REV.	С
#	-	D3278		SHEET 2 OF	3
DATE		TITLE		SCA	LE
07.07.24		SUPPORT A	ASSEMBLY		1:1



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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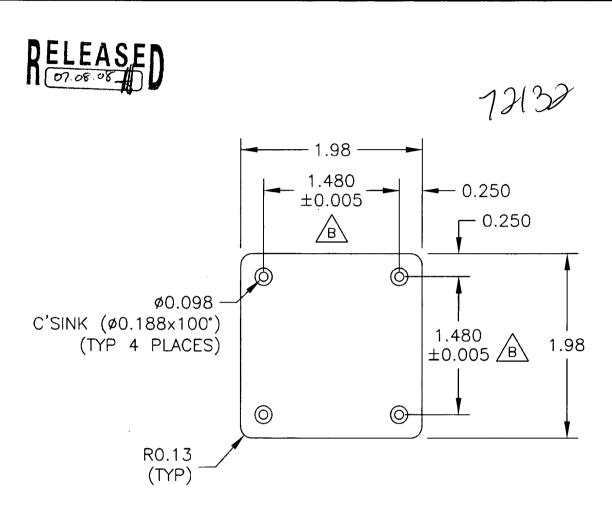
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROC	EDURE CH	DURE CHANGE		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQA:	Date: _				
Resolution:		esolution:	Disposition:		_ QA: N/C Cld	osed:	Date: _				
NCR:	:	W	ORK OR	DER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section B		Verification		Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
i i											

NOTE: Date & initial all entries



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CHECKED	APPROVED	DRAWING NO.	REV. C
A	-#	D3278	SHEET 3 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL (REF. DART SPEC. M-DELRIN-B0.125×2.000) OR DELRIN II 150E OR ACETRON GP ACETAL
- (REF. DART SPEC. M-DELRIN-S.125)
 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:	•		W	ORK ORDER CHANG	ES				***************************************
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								-	
			···						
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
					A: N/C Closed: Date:				
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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